

# Work Order ID 60315

Thursday, July 01, 2010 1:13:42 PM



Page 1

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 7/1/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: *10-7-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3911	C								

100

0.00



Bandsaw

0.00

*af 10.7.15*

*10*

*0*

Jeaspa Bandsaw

Memo

Cut blank to 2.885" long

*303 2 + 1.75*

110

0.00



HAAS 1

0.00

*af 10.7.15*  
*B.A 10/07/17*

*10*

*0*

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA917 & dwg,

FOLIO REV: *HA*

DWG REV: *C*

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 7/1/2010 Start Qty: 10.00



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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	S.A 10/07/17			10	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	MW 10/07/19			10	0		
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>94</u>  Memo	0.00 0.00				10.7-20	10.7-20		

W/O:		WORK ORDER CHANGES						
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Page 3

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Revision ID:

Stop



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Start Date: 7/1/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/8/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/21

MF  
10-7-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 01, 2010 1:13:47 PM

Page 1

Work Order ID: 60315



Parent Item: D3911-3



Parent Item Name: Aft Eyebolt Receiver

Start Date: 7/1/2010

Required Date: 7/8/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC  
AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	1 f	21.9059	0.26	2.736842			



303 BAR 2" X 1.750"



Location

Loc Qty

Loc Code

MAT

21.5934

115047 ✓

21.5934

MAT53

0.31251

113310

0.31251

2.736842 + B.A 10/07/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

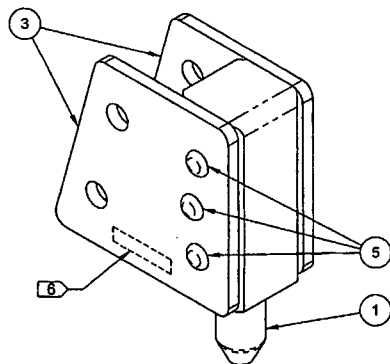
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

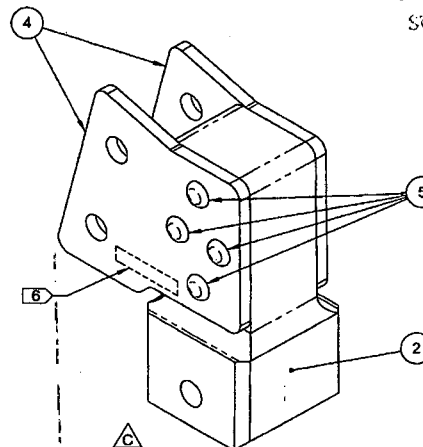
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



**D3911-041 BASKET INSTL STUD ASSY (LOWER)**

**NOTES:**





- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs  
-043: 0.99 lbs C



**D3911-043 AFT EYEBOLT RECEIVER ASSY**

SHOP COPY  
SUBMITTED TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40315  
BP10-7-01

**RELEASED**  
2010-04-14  
JPH

C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-5 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).		JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. C	
MFG. APPR.		D3911	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		AFT HARDPOINT, BASKET	NTS	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

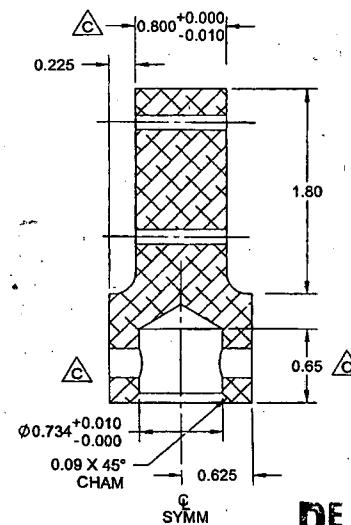
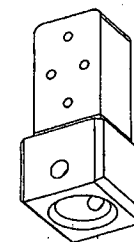
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
2010-04-14

- 6) IDENTIFICATION: ID  
7) WEIGHT -1: 0.36 lbs  
-3: 0.73 lbs

DESIGN	JPH	 <b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. 0	
DRAWN	JPH			
CHECKED			DRAWING NO. <b>D3911</b>	SHEET 2 OF 2
MFG. APPR.			TITLE	SCALE
APPROVED			<b>AFT HARDPOINT, BASKET</b>	NTS
DE APPR.			COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT &amp; ALL RIGHTS THEREIN ARE RESERVED BY DART AEROSPACE LTD. NO REPRODUCTION IN ANY FORM OR BY ANY MEANS IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	
DATE	10.04.06			

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**NOTES:**  
1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
PER DART SPEC M304S11GA OR M303S11GA

- [illegible]

**D3911-7 BASKET PLATE-EYEBOLT RECEIVER**

RELEASED  
2010-04-14

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3911</b>  TITLE <b>AFT HARDPOINT, BASKET</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISCLOSURE OR REPRODUCTION OF THIS DOCUMENT WITHOUT IT BEING NOT TO BE USED FOR ANY PURPOSE OR CONSIDERED OR REPRODUCED IN ANY MANNER WITHOUT PERMISSION	REV. C
DRAWN	JPH		SHEET 3 OF 3
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 10.04.06			

W/O:		WORK ORDER CHANGES						
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